

Work Order ID 86130

86130

Page 1

June-21-12 8:24:29 AM

Item ID: D3770-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tube

Start Date: 21/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3770

Rev B

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1-cut tube to lenght as per dwg D37702-drill holes thru to finish size as per dwg D3770 Using DT94123- deburr

6 Ø FF
12-06-28

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

07/06/30

(76)

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

6 12-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <i>ST 250</i>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

12/7/3 *(6)*

6x *SP*
12-7-3

12/7/4

12-07-4

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Picklist Print

June-21-12 8:24:33 AM

Page 1

Work Order ID: 86130

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Parent Item: D3770-3

D3770-3

Parent Item Name: Tube

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-07-21 revB as per dwg DD verified by:EC
IPP Rev:B Added Drilling Tooling 08-08-27 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W065		Purchased		No		100	f	85.9465	1.8125	11.44737			
M6061T6T1 000W065										**			
6061T6 RD TUBE 1.00 x .065w													

Location

Loc Qty

Loc Code

MAT015

85.9465469

114089

0.3114

116720

1.2

117983

24.4351469

122146

60

11.44737

⑥ 12-06-28

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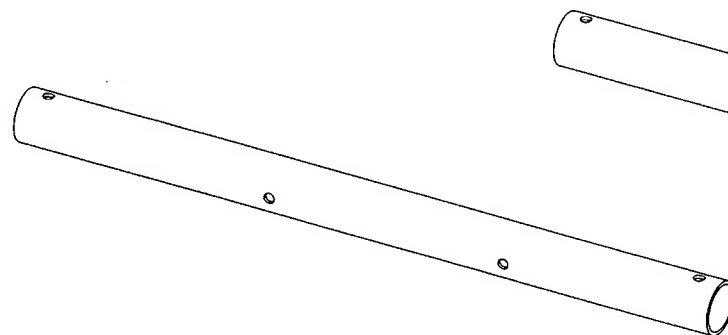
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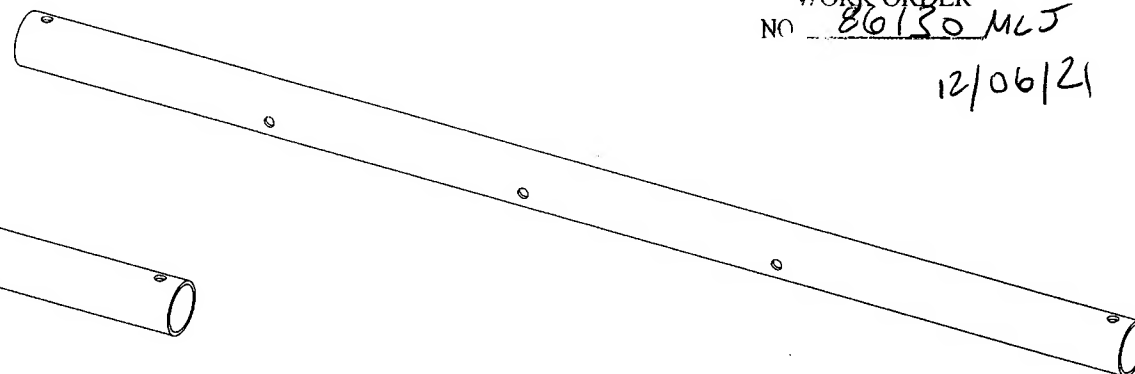
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO 86130 MJS

12/06/21



D3770-1 TUBE



D3770-3 TUBE

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M8061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3770-1, 0.25 lbs
 D3770-3, 0.40 lbs

B	CHANGE HOLES SIZE TO 0.201	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3770 TITLE TUBE REV. B SHEET 1 OF 3 SCALE NTS	
DRAWN	HS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	08.06.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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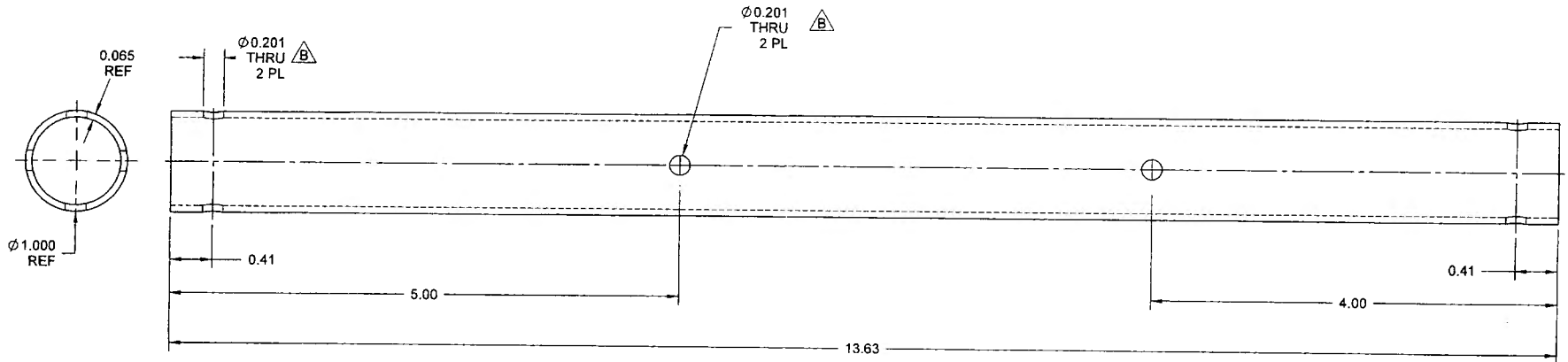
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D3770-1 TUBE

RELEASED
08.07.10

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3770	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		TUBE	NTS
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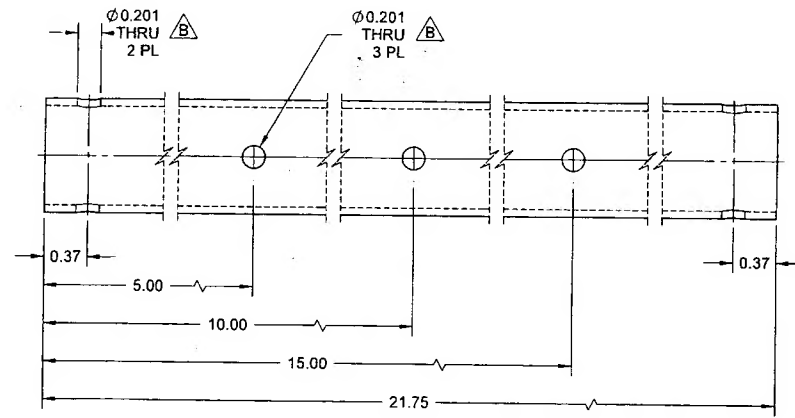
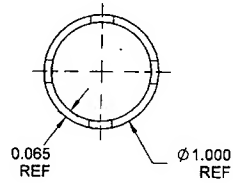
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D3770-3 TUBE

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05.07.10

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CHECKED	PA	DRAWING NO.	REV. B
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